

20-8453



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

UNDER REVIEW

SAW 19/05/17

URF19-568

D3304-041

Job Sheet 195356



Part No: D3304-041

Job Qty: 4 pcs

Part Name: Tube Assembly



Part Weight: 0 lbs

Status: New

Job Created: 5/17/19

Job Tracking No:

Due Date: 5/31/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: URF 19-568 DWG REV B IPP: C 04.11.17 Step 13 revised KJ/JLM

Ship Via:

POSITIVE RECALL

EFFECTIVE 19/05/17 AUTH SAW

RELEASED 9-89 DATE 20-04-03

9-89 Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	4 pcs		5/31/19	0.00	1.16	Bandsaw - 1			DAS 71 19-5-27 9-89
110	Conventional Lathe - 1 - B4B	4 pcs		5/31/19	0.00	2.22	Conventional Lathe - 1 - B4B			DAS 71 19-5-27 9-89
120	QC 2	4 pcs		5/31/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
QC 2 - 50										
QC 2 - 51										
QC 2 - 52										
QC 2 - 57										
QC 2 - 62										
QC 2 - 63										

ART
OSPACE

No: S184366



04 - 041
95356
Batch: S184366

Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Newbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/27/19



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S184366



Part No: D3304-041

Job No: 195356

Serial No/Batch: S184366

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/27/19

Plex 5/17/19 1:39 PM Dart.lajeunesse.marie

130 QC 8	4 pcs	5/31/19	0.00 0.00	QC 2 - 8	
				QC 2 - 66	DAS
				QC 2 - 64	71
				QC 2 - 65	9-89
				QC 2 - 5	
				QC 2 - 71	19-5-27
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	19-06-06
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Small Fab - 2 - B4B	4 pcs	5/31/19	0.00 0.93	Small Fab - 1 - B4B	DAS
				Small Fab - 2 - B4B	71
				Small Fab - 3 - B4B	9-89
				Small Fab - 4 - B4B	19-6-18
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
150 QC 5	4 pcs	5/31/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	DAS
				QC 5 - 40	40
					9-89
					11. 07 2019
160 Large Fab - Welded Assy-2-B4B	4 pcs	5/31/19	0.00 1.28	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	

					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
170 QC 9	4 pcs	5/31/19	0.00 0.00		QC 9 - 10	
					QC 9 - 18	DAS
					QC 9 - 24	24
					QC 9 - 43	9-89
					QC 9 - 50	
					QC 9 - 9	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
180 QC 5	4 pcs	5/31/19	0.00 0.00		QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	DAS
					QC 5 - 43	24
					QC 5 - 49	9-89
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
190 Powdercoat - 3 Gray Sand - B4B	4 pcs	5/31/19	0.00 0.16		QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
200 QC 3	4 pcs	5/31/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
210 Small Fab - 3 - B4B	4 pcs	5/31/19	0.00 0.93		QC 3 - 24	
					Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	

JUL 17 2019

JUL 17 2019

JUL 19-7-17.

SMB
19/7/17SMB
19/7/17POSITIVE
RECALL

Part Op 110 - Cut blank: 15.75" as per Dwg D3304 Turn as per Dwg D3304 Identify as D3304-1
Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

- 130 - QC8- Inspect parts - second check)
 140 - Deburr Drill as per Dwg D3304 using drill Jig D3304-T1 Deburr
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - Weld bracket as per Dwg D3304 and QSI 004
 170 - (QC9- Inspect visual per QSI004- Fusion Welds)
 180 - QC5- Inspect part completeness to step on W/O)
 190 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 200 - (QC3- Inspect Part Finish)
 210 - Assemble lanyard and pip pin as per Dwg D3304 MANUFACTURE LANDYARD AS PER D2690-10 DWG
 220 - (QC5- Inspect part completeness to step on W/O)
 230 - (Identify as per dwg & Stock Location: _____)
 240 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.875W.065	304 Round Tube .875 X .065W	5.3748 ft (1.3437 ea)	100-Bandsaw - 1	5126574
D3304-5	Bracket	4 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	5119599
BLBS-0016	Pip Pin <i>STSS6</i>	4 pcs (1 ea)	210-Small Fab - 3 - B4B	5079127
CBL-1240	Cable	4.1668 ft (1.0417 ea)	210-Small Fab - 3 - B4B	5197025
CBL-460	Loop Sleeve	8 Ea (2 ea)	210-Small Fab - 3 - B4B	5187877

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M304TR0.875W.065	5	33	0
160-Large Fab - Welded Assy-2- B4B	D3304-5	4	18	0
210-Small Fab - 3 - B4B	BLBS-0016	4	14	0
	CBL-1240	4	416	0
	CBL-460	8	70	0

Part Specifications

Specifications could not be found.

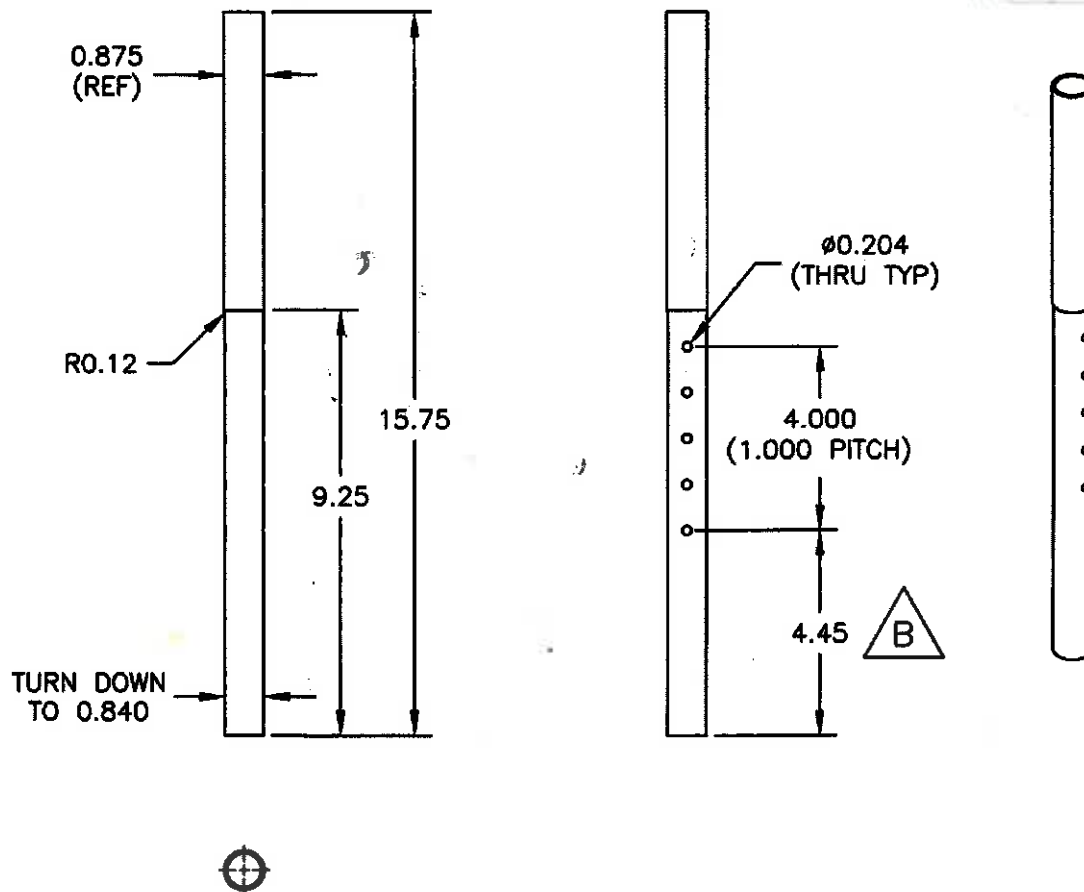
Plex 5/17/19 1:39 PM Dart.lajeunesse.marie

UNDER REVIEW

URF 19-568 19.02.08 (SAD)



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3304	REV. B SHEET 2 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4



D3304-1 TUBE

D3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

